Work Orde		3.7		*982	73*						Page 1	
Revision ID:	D3926-1			Accept	*N900	040	100)* s	Setup Sta	17	S1*	
		tart Qty: 4.00 eq'd Qty: 4.00	*4* *4*		Cust Item 1 Customer:	ID:				IV	S2*	
Approvals:	Process Plan: QC:		Date: \\(\frac{13-03-15}{}\)	Tooling: SPC (Y/N):		ate:		F		o n	R1* R2*	
Sequence ID/ Work Center II		peration escription		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	many 4
Draw Nbr	Revisio	on Nbr							****			
D3926	Rev A											
*100 *100* Waterjet FLOW CNC Waterj	et		Dwg D3926	0.00				¥	_ 0	,	<u>Jm</u> 13	-4-1
		Dwg Rev:_ Prog Rev:_ 2-Deburr if	necessary	,								
*110 *110* OC	Q	C2- Inspect parts off m	nachine FAI/FAIB	0.00				4	_ 0	·	Jm13-	4-4

Memo

Quality Control

NCR: Y	es / No				WORK ORDER NON-O	CONF	ORI	MANCE / UP	DATE			
										QA Closed:	Date:	<u> </u>
Work Orde	r:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
					Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	0.				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is] -	Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR No.				Work Order Update		Large Fab Composite				Supplier		
Root Descri			ption of work order update		tial	Act	tion	Sign &				
Cause	Date	Step	Qty	,	or Non-conformance	Chie	f Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling		<u> </u>				-				1	`	
Operator												
Material												
Setup												
Other												
Process												
Supplier	_					1						
Training	_											
Unapproved		<u> </u>								<u> </u>		
		****				AULT	CATE	GORY				
Landin	g Gear			<u></u>	General					10 11 11	Г	7
-	Bending			a (c	Bend	——	rain		-	Ovalized	4-1	Pressure/Forced
	Centre No	ot Concer	ntric to	^{0/S} -	BOM/Route	\vdash	ardwa		<u> </u>	Over/Under	 	Temperature/Cure
-	Cracks	o:		.	Broken/Damaged	-	-	ion Incomplete		Part Incorre	<u> </u>	Weld Wrong Stock Pulled
-	Crushed/	Crimped.		<u> </u>	Burrs	_		tions Incomplete/lenance	Unclear	Part Lost/Mi	ssing	Jwrong Stock Pulled
-	Cuffs			-	Contamination	\vdash				Part Moved	M	
F	Heat Trea		Tuka	-	Countersink	-	lislabe		 	Positioned V Power Loss/		Other
-	Inspection	-	rube	-	Cut Too Short Drill Holes	⊢	lisread ffset	ı	L.,	Jeower ross/	ourge	Totaler
	Ripples in		·		- 			Calibration				
}	Torque W			n	Drawing	\vdash		Sequence				
4	Turning S	equence		L	Finish	\square	ut or :	sequence				

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde March-12-13 1:		273		*982	73*					Page 2
Revision ID: Item Name:	D3926-1 Wedge 3/06/13 3/29/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*	Accept	*N90004 Cust Item ID: Customer:	.010	n *	Setup Si	I VI	S1* S2*
Approvals:		an:	Date:	Tooling: SPC (Y/N):	Date:Date:]		tart *N top *N	R1* R2*
Sequence ID/ Work Center II 120 *120* QC Quality Control	D	Operation Description QC8- Inspect parts - seco	nd check	Set Up/ Run Hours 0.00	Tool ID Too	ol# Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*130 *130* Small Fab Small Fab		Memo I- Deburr if	necessary	0.00	Ay ,		宴			
140 *1 4\O *	·	QC5- Inspect part comple	eteness to step on W/O	0.00						
Quality Control		Memo								

NCR:	NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE															
										· · · · · · · · · · · · · · · · · · ·	QA Closed:	Date:				
Work Orde	er: _					DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Part No				Rework Scrap Use-as-is Work Order Update	Scrap Machining Small Fa Use-as-is Thermoforming Finishin				-	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other					
Root	I			l	Descri	ption of work order update	T	Initial	Act	tion	Sign &					
Cause		Date	Step	Qty		or Non-conformance	1	nief Eng	1	ription	Date	Verification	QC Inspector			
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved			·						CODY							
Landi	na G	ioar.				General	AUL	T CATE	GURY		<u> </u>					
Landi		Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection Ripples in	Crimped t n Strip in Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	ion Incomplete ions Incomplete/ enance eled	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other			
	l	Torque W	aves in E	xtrusio	n [_	Drawing		Out of (Calibration							

Out of Sequence

Outside Dimensions

DQA: ____ Date: __

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde		8273		*982	73*				Page 3
Revision ID:	D3926-1 Wedge			Accept	*N900040	100	* Setu	p Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	3/06/13 3/29/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item ID: Customer:				
Approvals:	Process Pl	lan:	Date:	Tooling: SPC (Y/N):	Date:Date:		Run	Start Stop	"NRT"
Sequence ID/ Work Center II 150 *150* Packaging	D	Operation Description Identify as per dwg & St	ock Location:	Set Up/ Run Hours 0.00	Tool ID Tool #				Reject Insp. Number Stamp
Packaging 160 *160*		QC21- Final Inspection	- Work Order Release	0.00			(1)	3/4	13-4-9 100 DST

Memo

0.00

Quality Control

R: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:	Date:								
Work Order: DISPOSITION AGAINST DEPARTMENT/PROCESS	.s								
Rework Skid-tube Crosstube Water									
Part No Scrap Machining Small Fab Prod. Eng. Co Use-as-is Thermoforming Finishing Rec/Store/Packag									
NCR No. Use-as-is Use-as-is Thermoforming Finishing Rec/Store/Package Work Order Update Large Fab Composite Supp	* *H								
Root Description of work order update Initial Action Sign &									
Cause Date Step Qty or Non-conformance Chief Eng Description Date Verification	cation QC Inspector								
Doc/Data									
Equip/Tooling .	,								
Operator Operator									
Material									
Setup -									
Other									
Process									
Supplier									
Training									
Unapproved									
FAULT CATEGORY									
Landing Gear General Bending Bend Grain Ovalized	Pressure/Forced								
Bending Bend Grain Ovalized Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance	· ·								
	Weld								
Cracks Broken/Damaged Inspection Incomplete Part Incorrect Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing	Wrong Stock Pulled								
Cuffs Contamination Maintenance Part Lost/Missing	Mytolig Stock Pulled								
Heat Treat Countersink Mislabeled Positioned Wrong									
Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge	Other								

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID:

98273

Parent Item:

D3926-1

Parent Item Name:

Wedge

Start Date: 3/06/13

Required Date: 3/29/13

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP RevA: New issue DD verified by:EC

Comments:	IPP Reva: New iss	de DD vermed by	V.EC										
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10 UHMW 1" Black		Purchased	No			100	sf	1,023.8550	0.3609	15195788 2.0		J	<u>m 13-4</u> -
				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT019		1023.854989							
				12127	8	12.0949895							
				12257	5	47.6							
				12322	9	53							
				12370	4	63.8			<u> </u>				
				12394	9	25.36							ı
				12416	7	7							
				12438	0	22			134	388			
				12438	2	393			·			÷	
				12475	8	400							

											DQA:	Date:	
NCR:	Yes /	' No				WORK ORDER NON-C	100	VFOR	MANCE / UPDATE		04 (1	Data	
							-				QA Closed:	Date:	
Work Ord	٥.					DISPOSITION			AGAIN	ST DE	PARTMENT	/PROCESS	
VVOIK OIG	er. <u>—</u>		· · · · ·			Rework	1		Skid-tube Crosstu	be]	Water Jet	Engineering
Part i	No.					Scrap	1		Machining Small F	_	Pro	d. Eng. Coor.	Quality
	_					Use-as-is	1		noforming Finishi	ng	Rec/Stor	e/Packaging	Other
NCR i	No					Work Order Update]		Large Fab Compos	ite]	Supplier	
								L					
Root						ption of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty	•	or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data	Ш			·									
Equip/Tooling	Ш												
Operator	Ш												
Material	Ш												
Setup													
Other	Ш												
Process	Ш												
Supplier	Щ												
Training							1					ļ	
Unapproved	oxdot						<u> </u>				<u> </u>		
							AUL	T CATE	GORY				
Landi	ng Ge					General		1		_	1		7
	$\boldsymbol{\vdash}$	ending				Bend	<u> </u>	Grain		\vdash	Ovalized	., -	Pressure/Forced
<u> </u>	⊢	entre No	t Concer	itric to	O/S	BOM/Route	<u> </u>	Hardwa		\vdash	Over/Under	—	Temperature/Cure
	\vdash	racks			<u> </u>	Broken/Damaged	\vdash	1	on Incomplete	-	Part Incorre	<u> </u>	Weld
		rushed/C	rimped.		<u> </u>	Burrs	<u> </u>	4	ions Incomplete/Unclear	-	Part Lost/M	issing	Wrong Stock Pulled
	 1	uffs			_	Contamination	-	Mainte		\vdash	Part Moved		
	H	eat Treat	t			Countersink	1	Mislabe	led	- 1	Positioned V	Vrong	

Misread

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	98273
Description: Wedge	Part Number:	D3926-1
Inspection Dwg: D3926 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.04	+/-0.030	1.64"	-		٧	Jomos
1.50	+/-0.030	1.535	_		V	
1.50	+/-0.030	1.213.	-		ν	
1.75	+/-0.030	1.752"	~		V	·
2.00	+/-0.030	2.003"	<u>_</u>		V	
2.92	+/-0.030	2.92"	-		ν	
1.00	+/-0.030	1.020-	_		V	
0.25	+/-0.030	6,243"	_		V	
0.25	+/-0.030	0,246"	_		V	,
3.71	+/-0.030	3.710	_		V	
1.00	+/-0.030	1.019,	_		V	
14.01	+/-0.030	14.01"	-		Т	Jismob
						1
			A 0			

Measured by: Jm

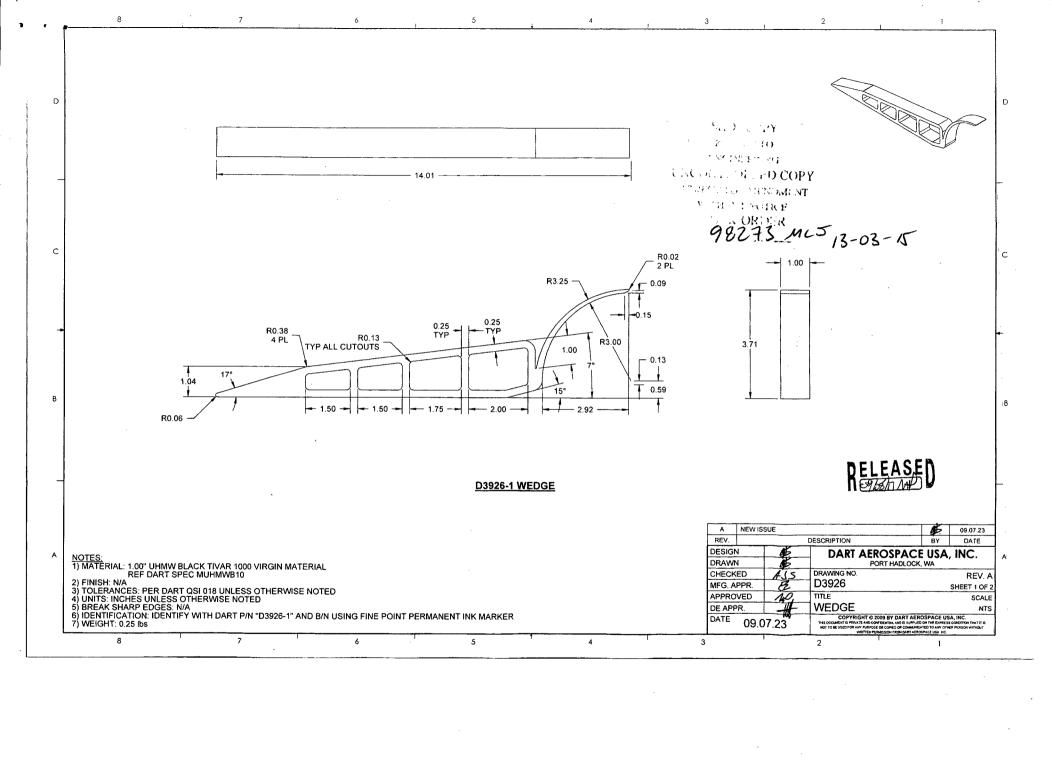
Date: 13-4-4

Audited by: Prototype Approval: N/A

Date: 15-4-9

Date: N/A

Rev	Date	Change	Revi	sed	by	Approved
Α	09.09.17	New Issue	KJ	*	}	
				77	<i></i>	770



0.25 TYP 1.00 R0.38 3 PL 0.25 TYP R0.13 TYP ALL CUTOUTS 3.24 R0.06 1.50 - 2.00 **D3926-3 WEDGE** DESIGN DART AEROSPACE LTD NOTES:
1) MATERIAL: 1.00" UHMW BLACK TIVAR 1000 VIRGIN MATERIAL
REF DART SPEC MUHMWB10 DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. REF DART SPEC MUHMWB10
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3926-3" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.25 lbs CHECKED REV. A D3926 MFG. APPR. SHEET 2 OF 2 TITLE APPROVED SCALE **WEDGE** DE APPR. NTS COPYRIGHT © 2009 BY DART AEROSPACE LTD
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